



Dart Aerospace Ltd.
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RBE350A93-3303-02

Job Sheet 170568



Part No: RBE350A93-3303-02

Job Qty: 6 ea

Part Name: T/R Body Extractor Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBE350A93-3303-02 REV 4 IPP REV A 18-01-17 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/27/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	6 pcs		2/27/18	0.08	6.00	Small Fab-9		MLL DAB
110	QC	6 pcs		2/27/18	0.00	0.00	QC5		36
130	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging3-2		EP 9-BB
140	QC21-FG	6 Ea		2/27/18	0.00	0.00	QC21		DAB 21 9-BB

Part Op 100 - -Assemble as per DWG. Sheet 1 -Loctite 262 B 138825 Exp: 10/19
Descriptions: 130 - Identify and Stock

MAR 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91030A031 GA 067	TBD	12 (2 ea)	90-Start up Operation	5038433
RBE350A93-3303-02-1 141	Receiver	6 Ea (1 ea)	90-Start up Operation	
RBE350A93-3303-02-3 141	Extractor	6 Ea (1 ea)	90-Start up Operation	
RBE350A93-3303-02-5 GA 141	Extractor Pin	6 Ea (1 ea)	90-Start up Operation	
RBE350A93-3303-02-7 GA 141	Stud	12 Ea (2 ea)	90-Start up Operation	5043552

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:22 AM Dart.lajeunesse.marie

OML 3-27



Container No: S054097



Part: RBE350A93-3303-02

Job No: 170568

Serial No/Batch: S054097

Revision: 4

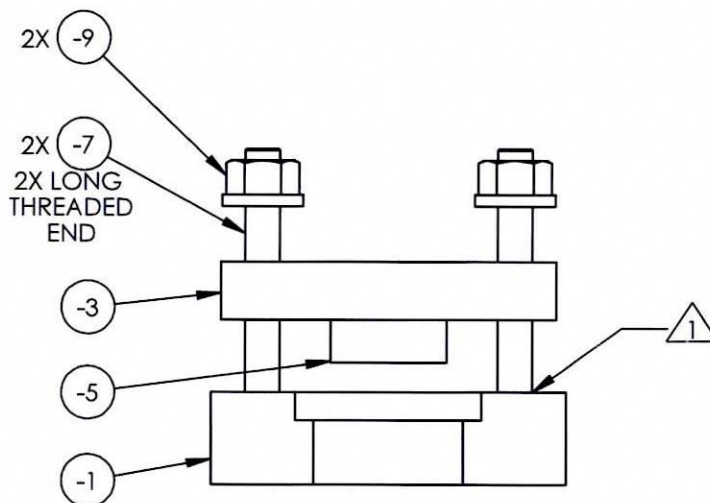
Inspector:

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Date: 03/22/18

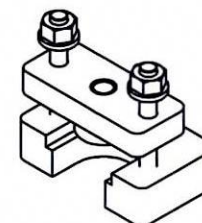
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D FROM HEX BOLTS & SET SCREWS TO STUDS. -1 ADDED R.25 TO CORNERS. -3 CH'D HOLES FROM Ø.413 AND ADDED R.25 TO CORNERS.	12/4/2008	WP	DW
2		-11 ADDED LOCTITE TO BOM. -5 ADDED .03 X 45° CHAMFER.	12/4/2008	WP	DW
2A		CORRECTED T/N AND TOOL NAME WAS RBEA93-3303-02, T/R HUB BODY EXTRACTOR TOOL IS RBE350A93-3303-02, T/R BODY EXTRACTOR TOOL.	11/5/2013	RJC	RW
3		-3 CH'D DIMS WAS Ø.500 IS LIMITS Ø.5000 - .5005, WAS .630 IS (.625). -5 CH'D DIM WAS Ø.501 IS Ø.5010 - .5015. -9 CH'D WAS SWIVEL HEX NUT #90477A031 IS FLANGE HEX NUT #91030A031.	3/13/2014	DPD	GE
4	15-0132	-1 & -3 CH'D MATERIAL WAS 1018 IS A36/1018/1020. -5 CH'D MATERIAL WAS 4140 G&P IS 4140/4142 Q&T.	6/10/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

170568 MJS
180117



NOTE:

1 2X LOCTITE ON THREADS -7 TO -1.

DART AEROSPACE	
TITLE T/R BODY EXTRACTOR TOOL	
DWG NO. RBE350A93-3303-02	REV 4
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER AS350A
SCALE 1:2	DATE 10/27/2008
SHEET 1 OF 5	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	A36/1018/1020		2
			-3	1	EXTRACTOR	A36/1018/1020		3
			-5	1	EXTRACTOR PIN	4140/4142 Q&T		4
			-7	2	STUD	STEEL	3/8-16 UNC-2A X 4 (MCMASTER-CARR #90281A640) MODIFIED	5
		B/O	-9	2	FLANGE HEX NUT	STEEL	3/8-16 UNC-2B (MCMASTER-CARR #91030A031)	1
		B/O	-11	AR	262 LOCTITE		(MCMASTER-CARR #91458A180)	N/S

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					